

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59633

Wednesday, June 09, 2010 8:43:53 AM



Page 2

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Assembly

Start Date: 6/9/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/141

count
(460)

140

Identify as per dwg & Stock Location: 471

0.00



Packaging

Memo

0.00

Packaging

10-6-17

604

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/17
MF 10-6-18

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Picklist Print

Wednesday, June 09, 2010 8:43:57 AM

Page 1

Work Order ID: 59633

Parent Item: D3278-041

Parent Item Name: Support Assembly

Comments: IPP: ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Start Date: 6/9/2010

Required Date: 6/17/2010

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 Support		Manufactured	No			100	Each	67.0000	1	60			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST048				67					
				51353				7					
				58183				60					
D3278-2 Support		Manufactured	No			100	Each	65.0000	1	60			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST048				65					
				55449				25					
				58184				40					
D3278-3 Spacer		Manufactured	No			100	Each	70.0000	1	60			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST049				70					
				53803				70					

60
6/10/06/10

60
6/10/06/10

25
35
60
6/10/06/10
60

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Required Qty: 60.00

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MS21042L4		Purchased	No			100	Each	3,921.000	2	120			



Nut

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	3919	
113422	68	
114523	843	
114718	1000	
114784	2000	
9063	8	

AN4-13A Purchased No



Bolt

Location	Loc Qty	Loc Code
ST357	215	
107959	2	
114752	213	

AN960JD416 NAS1149D0463J Purchased No



Washer

M114576 (240x)

Location	Loc Qty	Loc Code
ST357	18	
107939	18	



EP 5/10/06/14

EP 5/10/06/14

EP 5/10/06/14

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------



Lug

Location

Loc Qty

Loc Code

ST476

89

39315

4

51566

4

54755

5

57828

76

MS20426AD3-6

Purchased

No

120

Each

2,026.000

4

240



Rivet

Location

Loc Qty

Loc Code

ST316

2026

105055

2026



2
120
E 5/10/06/14
B 59/56 (100x)



20
240
E 5/10/06/10
240

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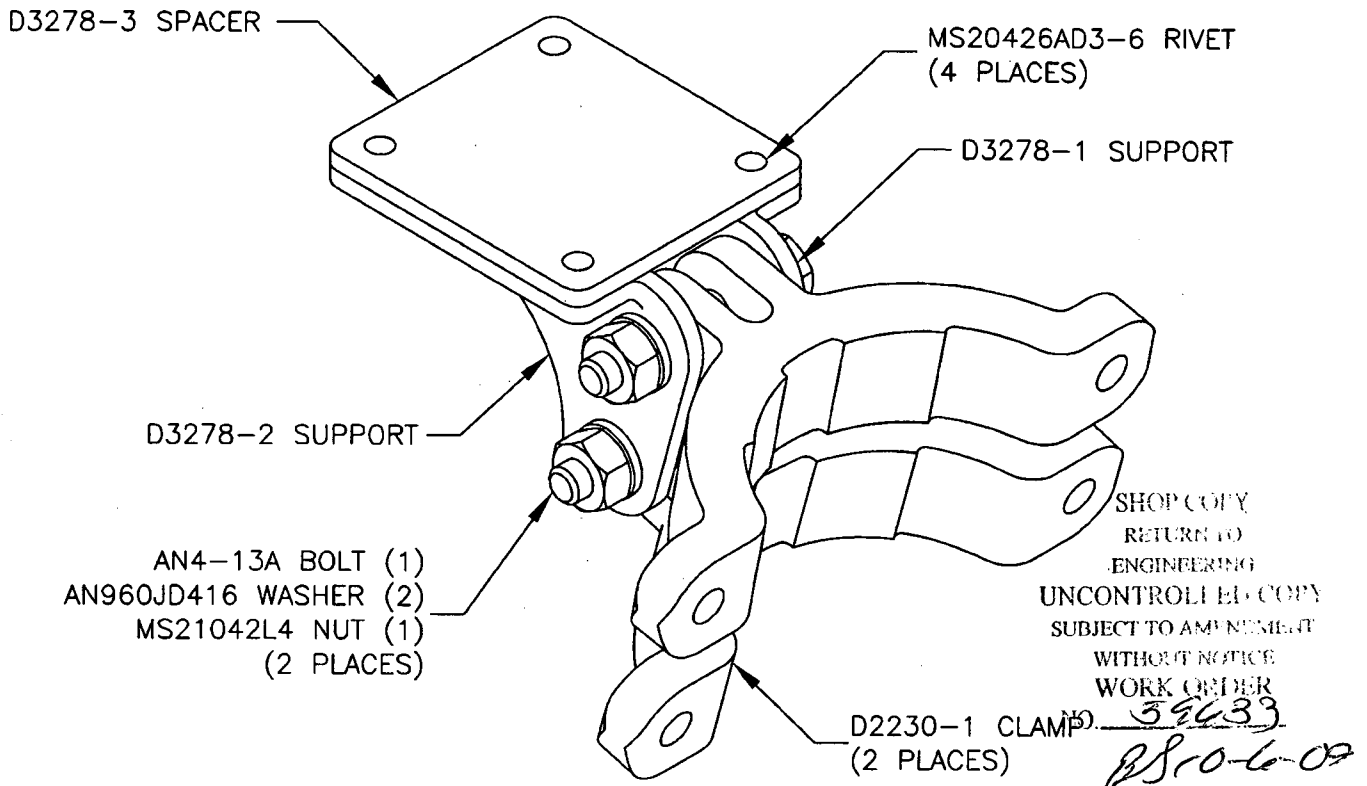
NOTE: Date & initial all entries

DART

DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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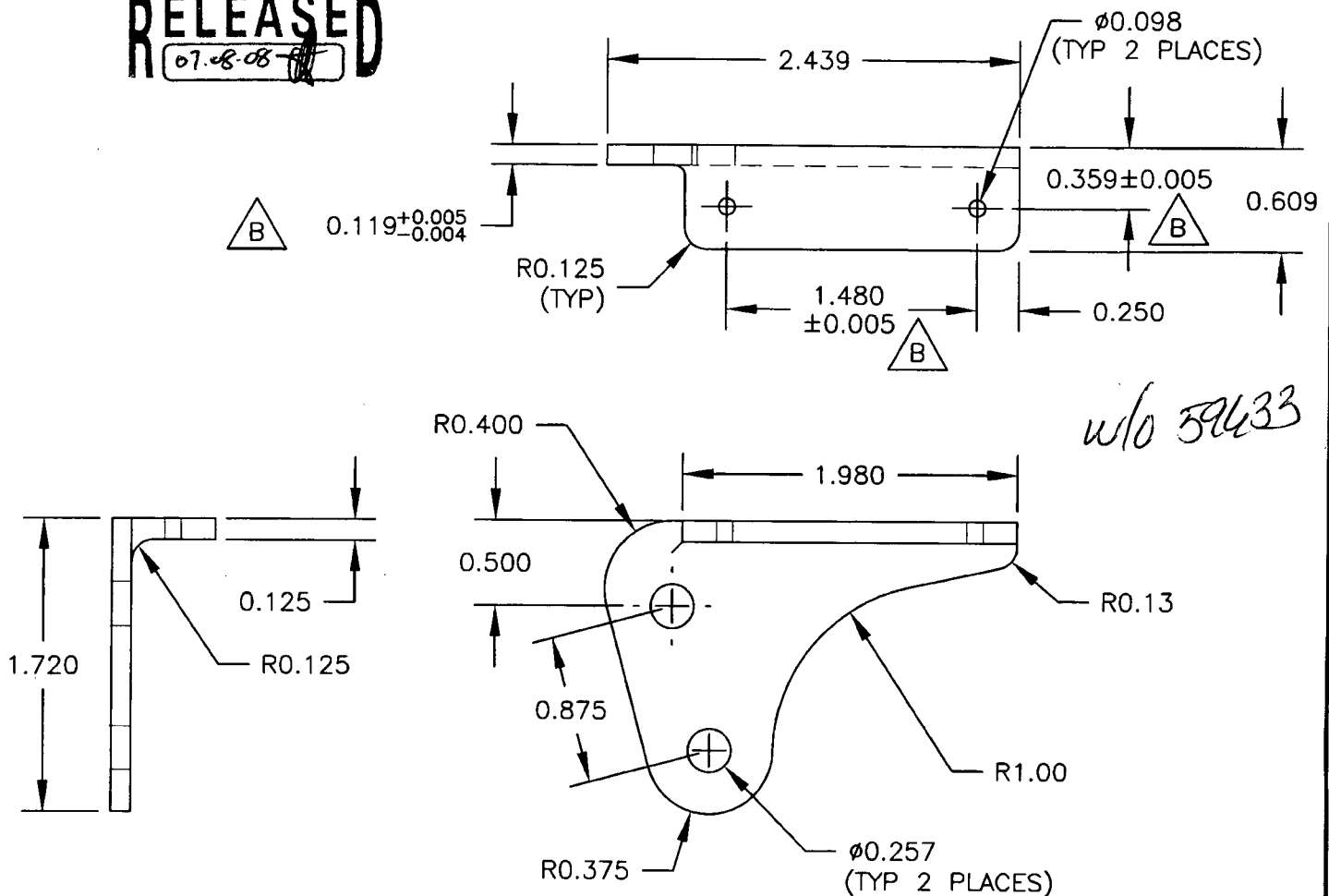
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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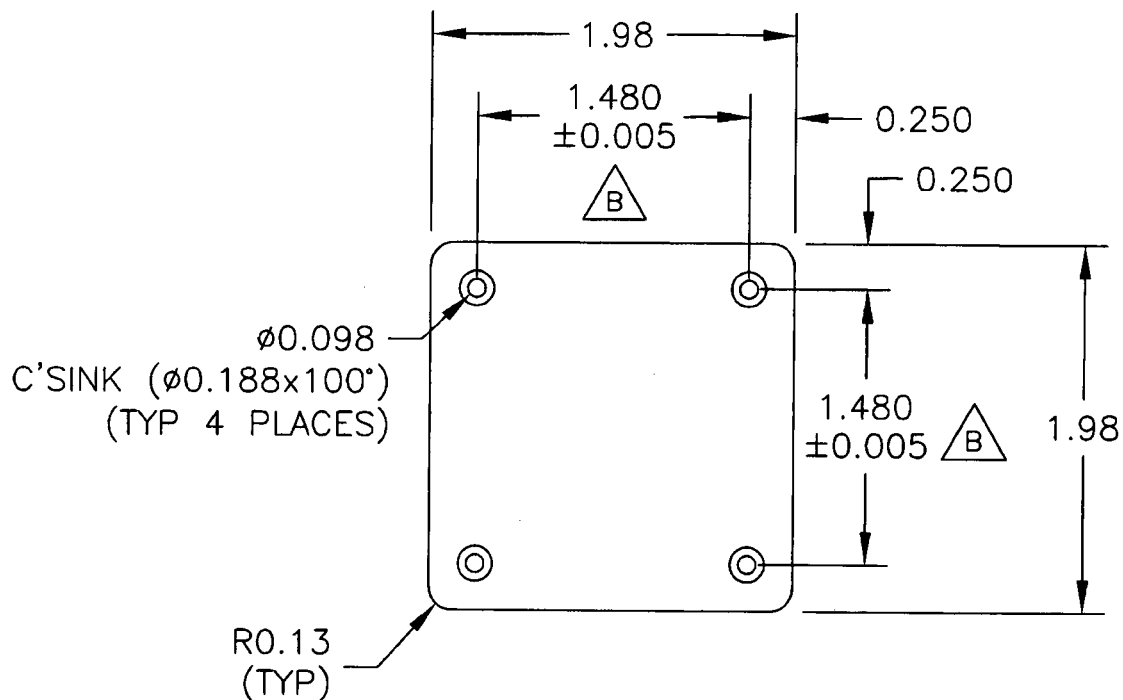
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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